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**Alvarez et al.**

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(54) **TRI-LAYER FOOD CONTAINER**

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5, 2007, now Pat. No. 8,592,014.

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**B65D 1/16** (2006.01)  
**B32B 7/12** (2006.01)  
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**B29D 22/00** (2006.01)

(52) **U.S. Cl.**

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(2013.01); **B32B 7/12** (2013.01); **B65D**  
**81/3867** (2013.01); **Y10T 156/1002** (2015.01);  
**Y10T 428/1307** (2015.01)

(58) **Field of Classification Search**

CPC ..... B29C 51/02; B29C 51/082; B29C 51/14  
See application file for complete search history.

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(57) **ABSTRACT**

A container for holding food or beverages includes an inner thermoformed sleeve and a molded insulating foam support layer. The inner sleeve and foam support layer each have a circumferential wall extending from a bottom wall. The foam layer is bonded to the thermoformed sleeve on the outside or inside of the sleeve. The container can also include an outer sleeve bonded to an outer surface of the foam support layer. The inner sleeve may be made of thermoformed polystyrene. The outer sleeve may be a paper label.

**9 Claims, 7 Drawing Sheets**

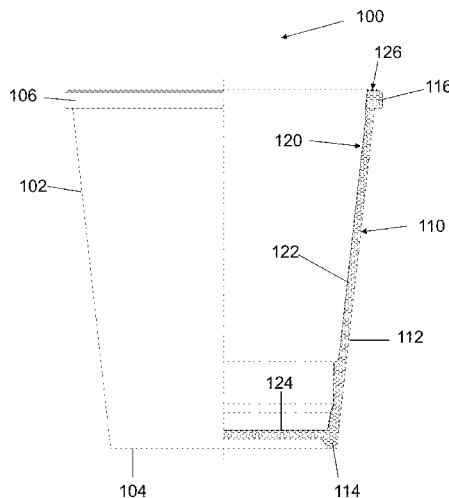


Fig. 1

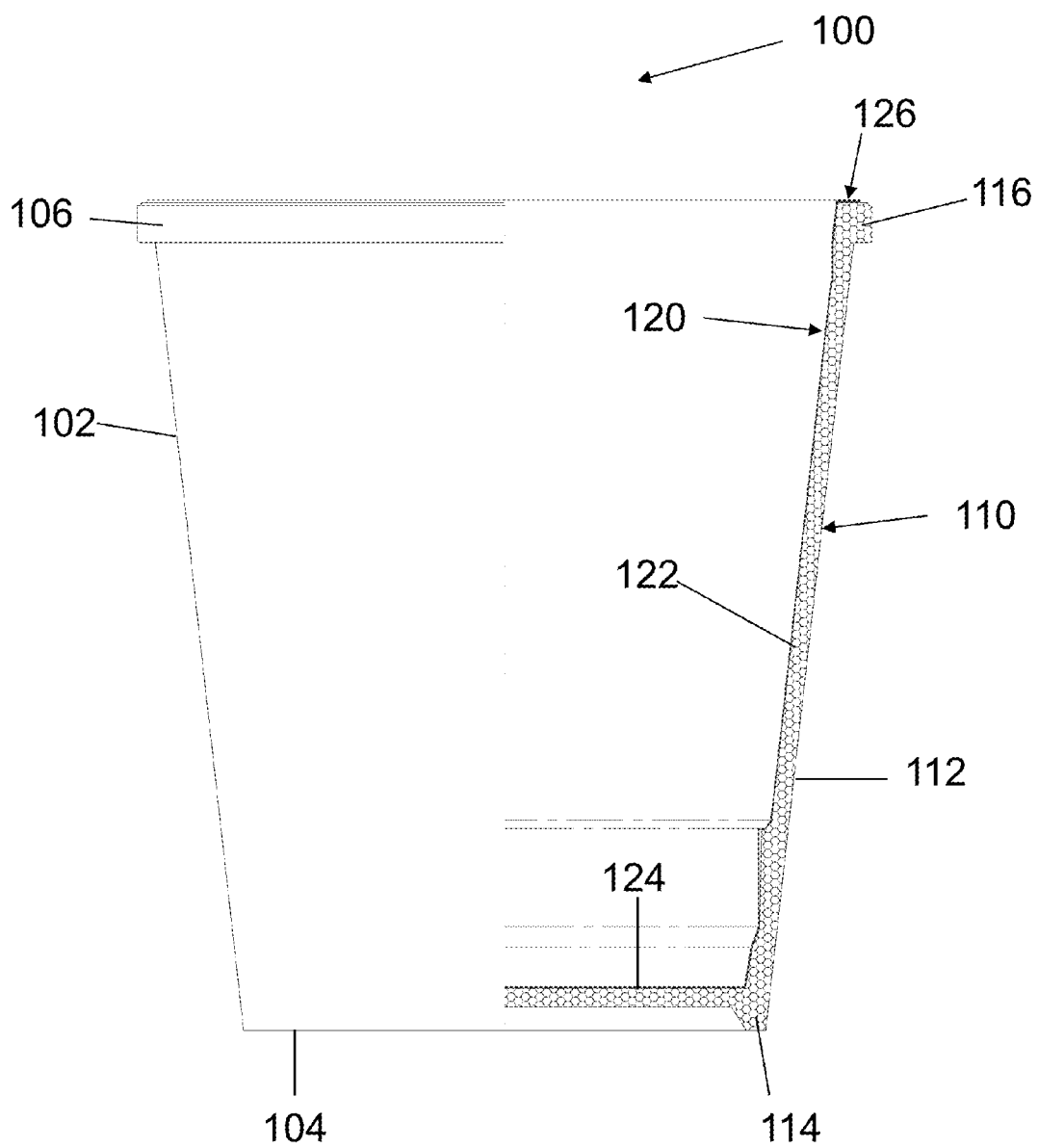


Fig. 2(a)

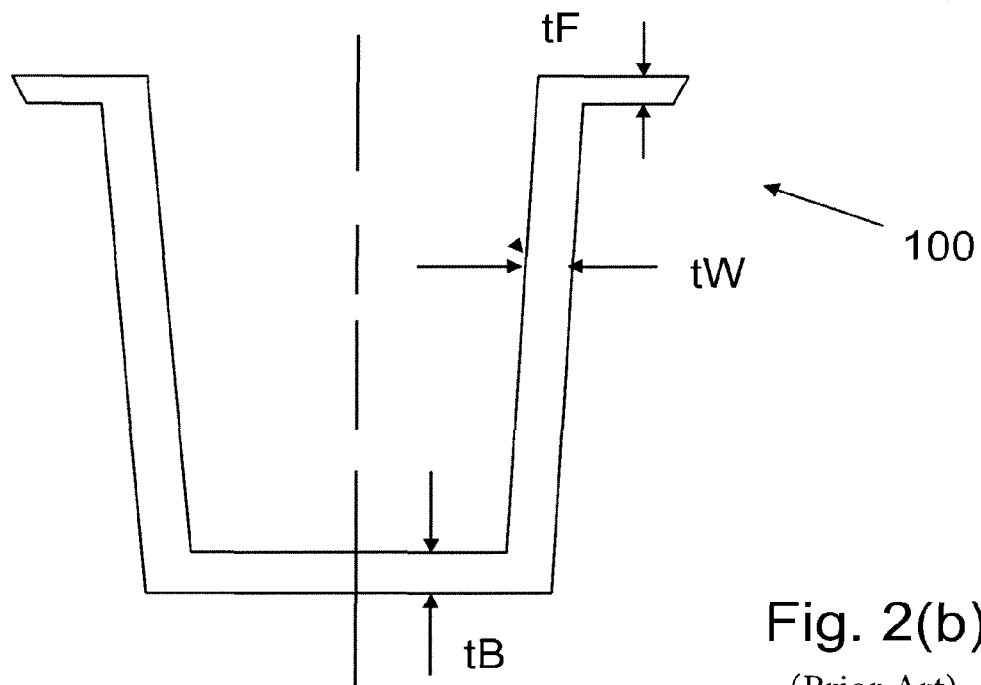
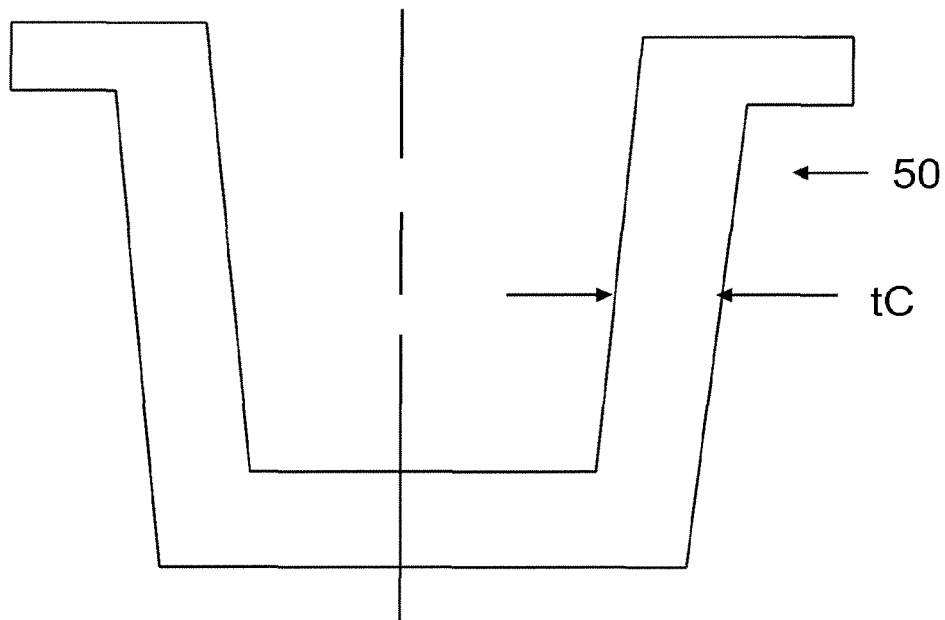


Fig. 2(b)  
(Prior Art)



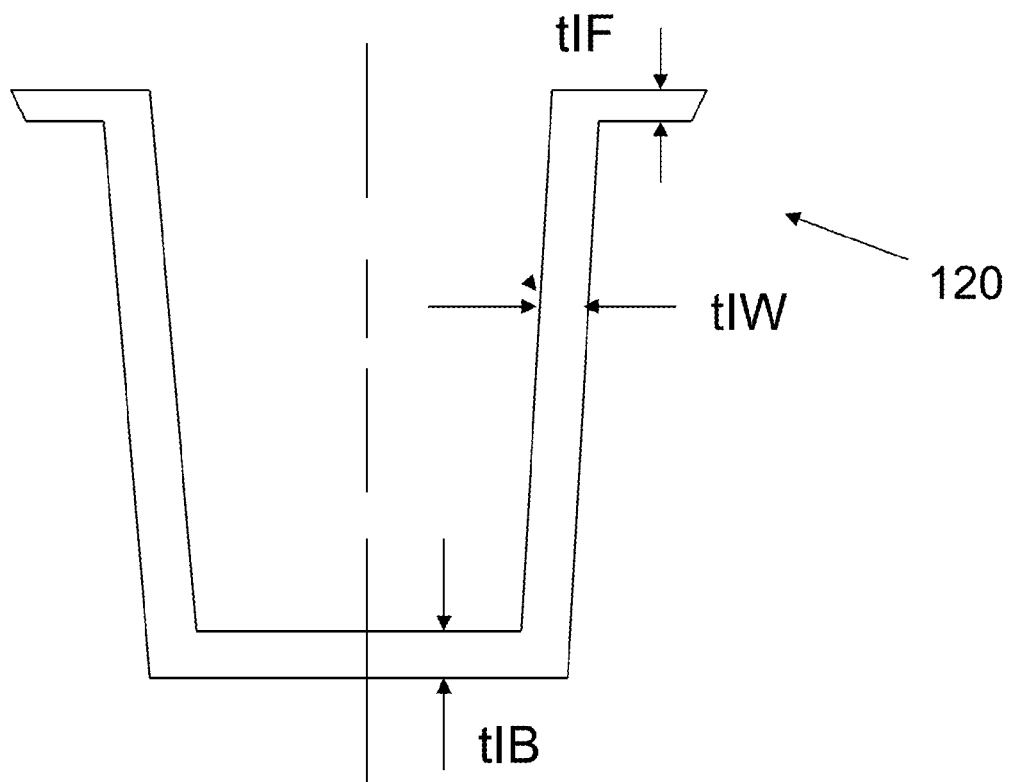


Fig. 3

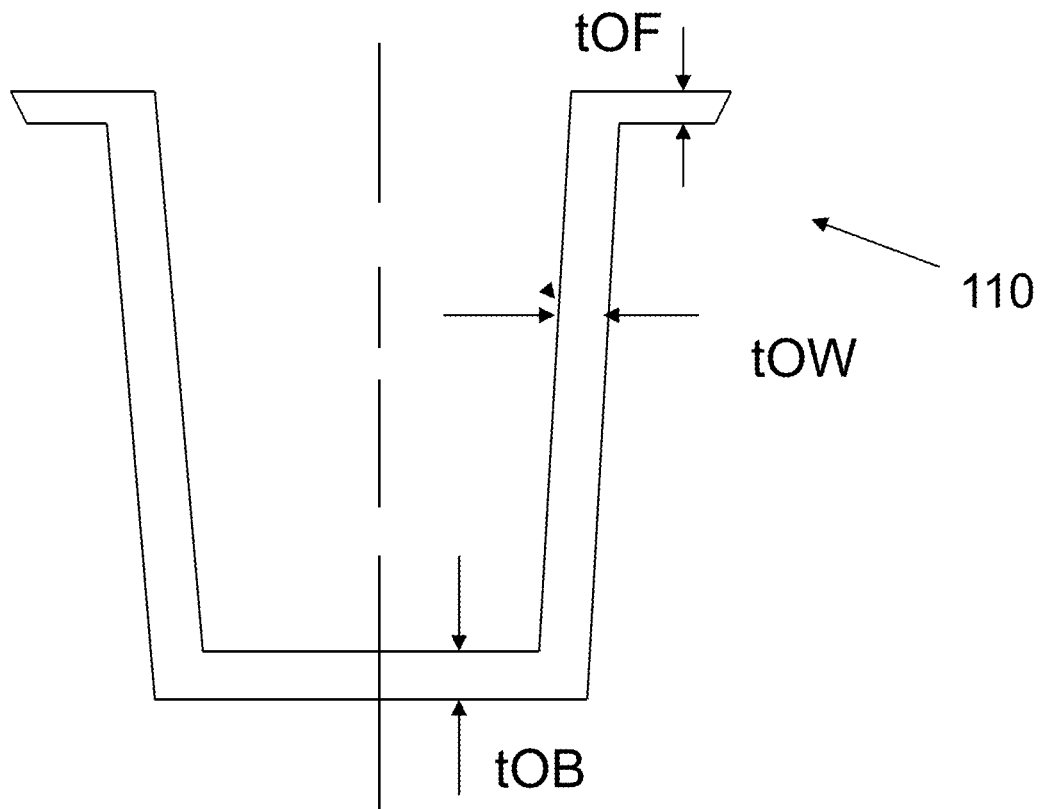
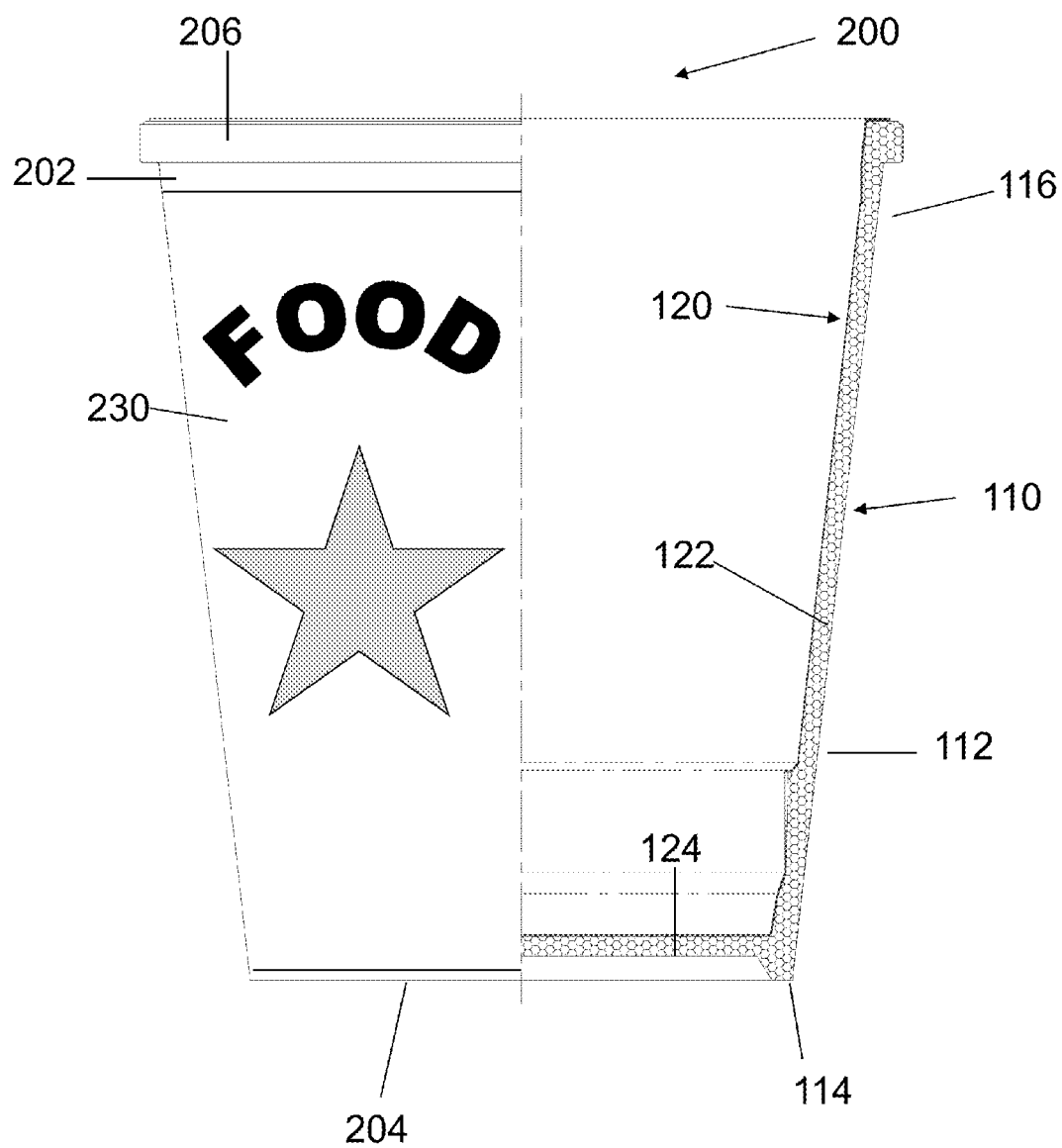


Fig. 4

Fig. 5



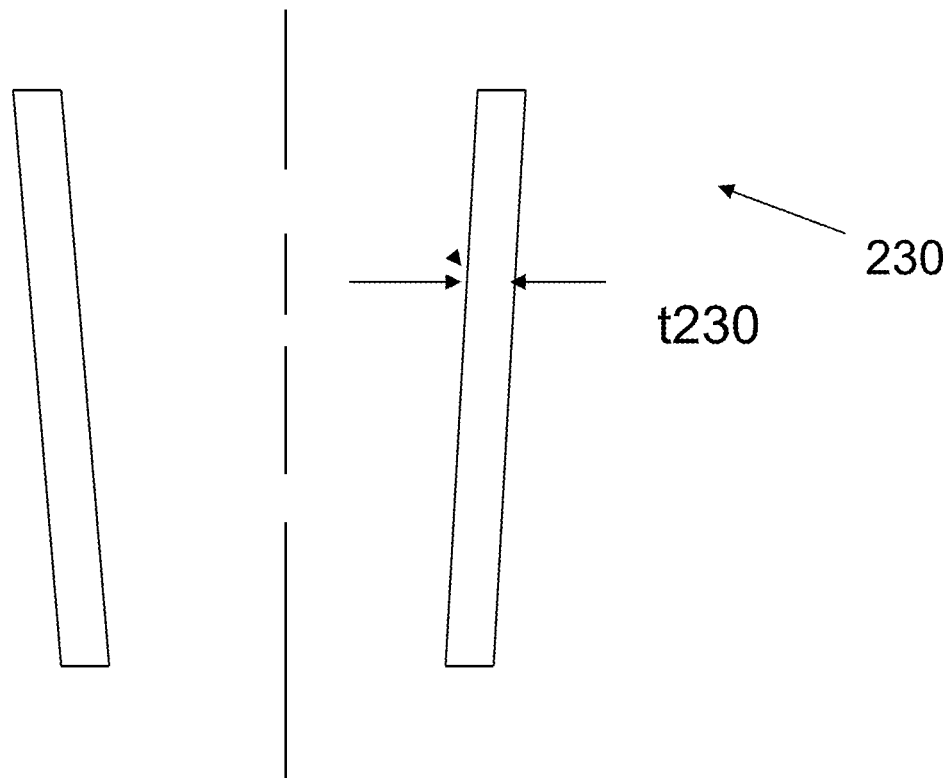


Fig. 6

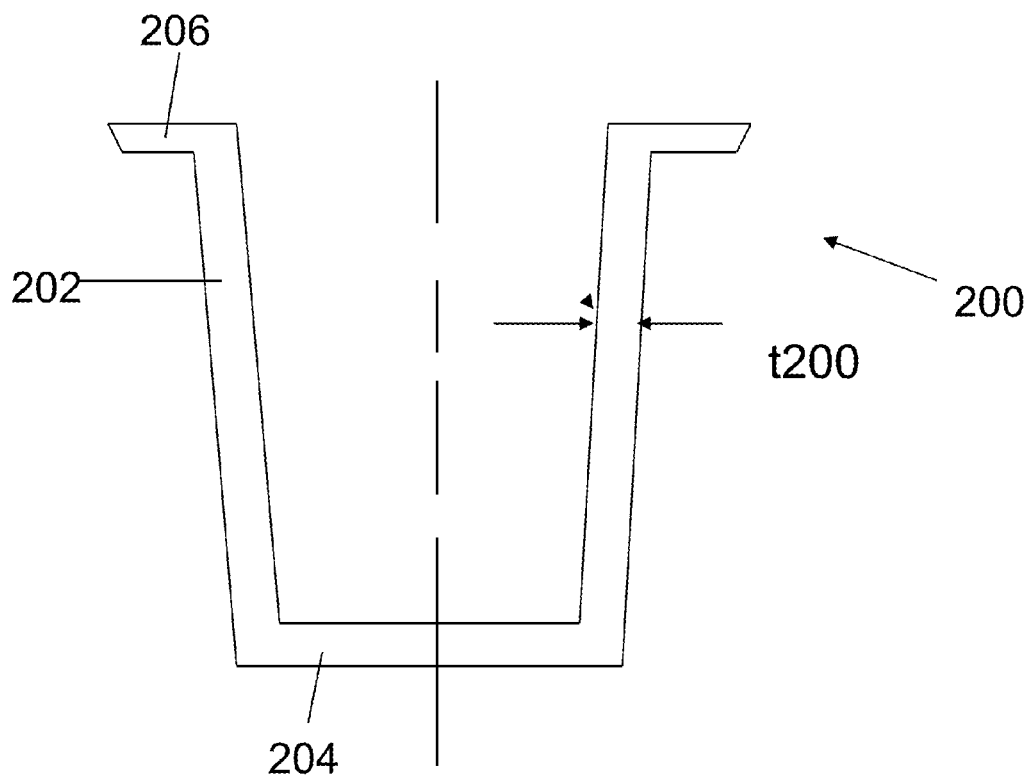


Fig. 7



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**TRI-LAYER FOOD CONTAINER****CROSS-REFERENCE TO RELATED APPLICATIONS**

This application is a divisional of U.S. application Ser. No. 11/702,120, filed Feb. 5, 2007, the disclosure of which is incorporated herein by reference in its entirety.

**FIELD OF THE INVENTION**

The present invention relates generally to a method for producing plastic foam containers with three layers. The invention further relates to a plastic foam container made of three layers, such as a cup for beverages or food items.

**BACKGROUND**

It is known to use plastic foam containers to hold food, drinks, or other substances. Conventional foam containers are generally inexpensive and have insulating properties. Conventional beverage containers may also be made of plastics.

Typical containers can leak substances, such as food or liquids, contained within. In some conventional containers, the substance may react with the container, causing the container to break down and leak the substance.

Furthermore, companies wish to advertise their product on the outer surface of the container. However, conventional foams or expanded polystyrene (EPS) containers do not receive and/or retain printed media clearly or effectively. The printed media may not adhere well to the outer surface or may not attach at all.

Some conventional containers have attempted to manufacture a foam cup with a plastic layer or film as a label. The plastic film may improve printability, but requires additional materials and amounts of materials, which can increase the cost associated with the materials as well as manufacturing time. Traditional labeling devices suffer from certain limitations. For example, it is often complicated to apply labels to foam containers with conical surfaces, such as cups. It is particularly difficult to cover substantially the entire outer surface of such a container, such as the entire outer wall of a cup.

An example of a conventional container is disclosed in U.S. Pat. No. 6,811,843 ("the '843 patent"). In the '843 patent, a seam is formed in the plastic layers forming the container. Another example of a conventional container is disclosed in U.S. Pat. No. 4,943,459 ("the '459 patent"). In the '459 patent, only a foamed plastic is used that is formed by a sheet. Such a method is known to be difficult to form a container that is drawable and, further, the plastic container formed by the '459 patent would have a seam.

It is therefore desirable to provide a container and a method of making the container that has good insulating properties, uses less expensive materials and is capable of having a printable surface across the entire outer surface of the container.

**SUMMARY**

According to an embodiment of the invention, a container is provided. The container comprises an innermost thermoformed plastic sleeve with a circumferential sidewall extending from a bottom wall. The innermost sleeve provides barrier resistance from material placed within the container. The thermoformed plastic sleeve is seamless. The container also comprises an insulating molded foam support layer with a

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circumferential sidewall extending from a bottom wall. The foam layer is bonded to the inner thermoformed sleeve. The foam support layer provides thermal resistance from material placed within the container. The foam support layer is also seamless. The container further comprises an outermost paper sleeve bonded to an outer surface of the foam support layer. The innermost sleeve has a higher density than the foam support layer.

Another embodiment of the invention provides a food container. The food container comprises a cup-shaped innermost thermoformed plastic sleeve with a circumferential sidewall extending from a bottom wall. The sleeve is seamless. The food container also comprises a cup-shaped molded plastic support layer that is seamless, and an outermost paper sleeve layer bonded to an outer surface of the support layer. The support layer includes a circumferential sidewall extending from a bottom wall with an inner diameter larger than an outer diameter of the inner sleeve such that the innermost sleeve is bonded to an inside surface of the support layer. The innermost sleeve has a higher density than the support layer. The innermost sleeve comprises the same plastic material as the support layer.

According to yet another embodiment of the invention, a method of forming a container is provided. The method comprises the steps of thermoforming a plastic sleeve with a bottom wall and upwards extending circumferential sidewall such that the plastic sleeve is seamless, and forming a molded one-piece insulating, beaded foam support layer with a bottom wall and upwards extending circumferential sidewall such that the support layer is seamless. The method also comprises bonding the plastic sleeve with the foam support layer to form a seamless container, and bonding an outer paper sleeve to an outer surface of the seamless container.

According to yet another embodiment, a container is provided. The container comprises an innermost thermoformed plastic sleeve with a circumferential sidewall extending from a bottom wall and an insulating molded foam support layer with a circumferential sidewall extending from a bottom wall. The innermost sleeve provides barrier resistance from material placed within the container. The thermoformed plastic sleeve is seamless. The foam layer is bonded to the inner thermoformed sleeve. The foam support layer provides thermal resistance from material placed within the container. The foam support layer is seamless. The innermost sleeve has a higher density than the foam support layer.

It is to be understood that both the foregoing general description and the following detailed description are exemplary and explanatory only, and are not restrictive of the invention as claimed.

**BRIEF DESCRIPTION OF THE DRAWINGS**

These and other features, aspects, and advantages of the present invention will become apparent from the following description, appended claims, and the accompanying exemplary embodiments shown in the drawings, which are briefly described below.

FIG. 1 is a partially cross-sectional view of a container with inner sleeve and outer support, wherein the sidewall of the container has a reduced wall thickness according to an embodiment of the invention.

FIGS. 2(a) and 2(b) are cross-sectional views of a container comparing the reduced wall thickness of the container of FIG. 1 compared to a known foam container wall thickness, in which FIG. 2(a) illustrates the thickness of the container of FIG. 1 and FIG. 2(b) illustrates the wall thickness of a known foam container.

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FIG. 3 is a cross-sectional view of an inner sleeve according to the container of FIG. 1 illustrating the reduced wall thickness of the inner sleeve.

FIG. 4 is a cross-sectional view of an outer support according to the container of FIG. 1 illustrating the reduced wall thickness of the outer support.

FIG. 5 is a partially cross-sectional view of a container with an inner sleeve, outer support and label layer according to another embodiment of the invention.

FIG. 6 is a cross-sectional view of the label layer illustrating the thickness of the layer according to the container of FIG. 5.

FIG. 7 is a cross-sectional view of the container illustrating the reduced wall thickness of the container of FIG. 5.

#### DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS

FIGS. 1-4 illustrate a container 100 according to an embodiment of the invention. The container 100 may be cup-shaped and used to hold or store food and beverage or other suitable substances.

The container 100 has a sidewall 102 extending from a bottom wall 104. The container 100 also has a lip 106 (or sometimes referred to herein as a “flange”) on a distal end of the sidewall 102 opposite the bottom wall 104. The container 100 is formed by a support layer 110 and an inner sleeve 120 bonded to the support layer 110. The container may also include an outer sleeve, such as described with respect to FIGS. 5-7 below.

The support layer 110 includes a circumferential sidewall 112 extending from a bottom wall 114 and a flange or lip 116. The flange 116 extends from an open end of the support layer 110 on a distal end of the sidewall 112 opposite the bottom wall 114. The support layer 110 has an inner diameter larger than an outer diameter of the inner sleeve 120 such that the inner sleeve 120 can be bonded to an inside surface of the support layer 110.

The inner sleeve 120 includes also includes a circumferential sidewall 122 extending from a bottom wall 124 and a flange or lip 126. The flange 126 extends from an open end of the inner sleeve 120 on a distal end of the sidewall 122 opposite the bottom wall 124. All or less than all of the outer surface of the inner sleeve 120, including the sidewall 122, bottom wall 124 and flange 126 is bonded to the inner surfaces of the support layer 110 to form an insulating, rigid container 100. The container 100 is preferably seamless. For example the inner sleeve 120 and/or support layer 110 are formed in such a manner that a one-piece, seamless container is created. The bonding of the inner sleeve 120 and support layer 110 creates a seamless container 100.

The inner sleeve 120 may be bonded to the support layer 110 by glue, such as with a hot mandrel. For example, the bonding of the inner sleeve 120 and support layer 110 may be accomplished by the method described in U.S. patent application Ser. No. 11/227,124 filed Oct. 1, 2004 (which is incorporated by reference herein in its entirety). Alternatively, the inner sleeve 120 and support layer 110 may be bonded together by any other suitable mechanism and/or method.

The inner sleeve 120 and support layer 110 are both made of polystyrene and, therefore, are able to bond together. The inner sleeve 120 may comprise a plastic, such as thermoformed polystyrene, expanded polystyrene (EPS), or any other suitable plastic or material. The inner sleeve 120 is preferably made of an unfoamed thermoformed polystyrene. Alternatively, the polystyrene may be foamed. The inner sleeve 120 provides barrier resistance for materials (such as

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liquids, food items, etc.) within the container 100. The inner sleeve 120 is the innermost sleeve of the container 100 and has a density higher than the foamed support layer 110.

The support layer 110 may comprise foam, such as a beaded foam, or any other suitable material. The foam support layer 110 may be molded or made by any other suitable method. The foam support layer 110 provides an insulating, thermal resistance from material in the container 100.

Alternatively, the inner sleeve 120 may be made of a foam and the support layer 110 may be made of thermoformed polystyrene.

The inner sleeve 120 can reduce the thickness of the walls of the support layer 110. The rigidity of the inner sleeve 120 allows for a thinner and, thus, less expensive support layer 110 of foam. For example, a conventional foam container 50, such as shown in FIG. 2(b) must use greater amounts of foam material with thicker walls in order to provide the stability, rigidity and barrier properties for a suitable food or beverage container. FIG. 2(a) illustrates the reduced wall thicknesses according to the container 100 of the first embodiment. As shown in FIG. 2(a) the sidewall thickness tW of the container 100 is less than or equal to the sidewall thickness tC of a known container 50 (FIG. 2(b)). The total wall thickness tW of the sidewall 102 may be in the range of about 2.0 mm to 2.6 mm; or more specifically, about 2.22 mm to 2.564 mm. The total thickness tF of the flange 106 and the total thickness tB of the bottom wall 104 can vary depending upon the overall size of the container 100. The thicknesses tF and tB are determined by the thermoforming process.

FIG. 3 illustrates exemplary thicknesses tIF, tIW and tIB of the inner sleeve 120. In the embodiment, the inner sleeve 120 may have bottom wall 124 with a thickness tIB in a range of about 0.10 mm to 0.16 mm. More preferably, the bottom wall 124 may have a thickness tIB in a range of about 0.12 to 0.14 mm. Alternatively, the thickness tIB may be in a range of about 0.101 mm to 0.127 mm. The thickness tIB of the bottom wall 124 may be uniform (thus, have a thickness tIB of 0.12 mm or 0.14 throughout), or it may vary along the length of the bottom wall 124.

The flange 126 portion of the inner sleeve 120 may have a thickness tIF in a range of about 0.25 mm to 0.4 mm. More preferably, the flange 126 has a thickness tIF in a range of about 0.3 mm to 0.36 mm. Alternatively, the flange 126 may have a thickness tIF in a range of about 0.1 mm to 0.13 mm; or more specifically, of about 0.101 mm to 0.127 mm. The thickness tIF of the flange 126 may be uniform (thus, have a thickness tIF of 0.3 mm or 0.36 mm throughout), or it may vary along the length of the flange 126.

The thickness tIW of the sidewall 122 may have a range of about 0.05 mm to 0.15 mm. More preferably, the thickness tIW of the sidewall 122 may have a range of about 0.05 mm to 0.13 mm. Alternatively, the thickness tIW of the sidewall 122 may have a range of about 0.1 mm to 0.13 mm; or more specifically, of about 0.101 mm to 0.127 mm.

The sidewall 122 may have varying thicknesses tIW along its length. For example, near the bottom wall 124, the thickness tIW may be about 0.10 mm, with the sidewall 122 decreasing to about 0.06 mm to 0.07 mm in a middle portion of the sidewall 122, and increasing in thickness near the flange 126 to about 0.13 mm. It will be recognized that this is exemplary only. In another example, the sidewall 122 may have a thickness tIW of about 0.09 mm near the bottom wall 124, a thickness tIW of about 0.05 mm to 0.07 mm in the middle portion of the sidewall 122 and a thickness tIW of about 0.15 mm near the flange 126. Alternatively, the thickness tIW of the sidewall 122 may be uniform throughout.

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In an example of the inner sleeve **120** with varying thicknesses, the diameter of the inner sleeve **120** near the flange **126** may be larger than the diameter of the inner sleeve **120** near the bottom wall **124**. Furthermore, the sidewall **122** may not extend from the bottom wall **124** as a straight line, but can have a varying profile. It will be recognized that the inner sleeve **120** can have any suitable shape, configuration, profile and thickness as appropriate.

The support layer **110** may have a thickness **tOW** of the sidewall **112** in a range of about 2.0 mm to 2.5 mm. Alternatively, the thickness **tOW** may be in a range of about 2.17 mm to 2.4 mm. The thickness **tOB** of the bottom wall **114** may have a range of about 2.0 mm to 2.5 mm. Alternatively, the thickness **tOB** may be in a range of about 2.17 mm to 2.4 mm. The thickness **tOF** of the flange **116** may have a range of about 2.0 mm to 2.5 mm. Alternatively, the thickness **tOF** may be in a range of about 2.17 mm to 2.4 mm.

According to a feature of the embodiment, the amount of resin or material used to form the inner sleeve **120** that is combined with the foam material of the support layer **110** is preferably less than a standard, comparably sized and shaped foam container. This is achieved by lowering the density of the foam support layer **110** and adding a thin, rigid inner sleeve **120**.

In an embodiment, the inner sleeve **120** has a weight in a range of about 2.5 grams to 3.5 grams. In an embodiment, the support layer **110** has a weight of about 4.5 grams to 5.5 grams.

In an embodiment, the container **100** has a total weight in a range of 2.0 grams to 2.7 grams. Preferably, the container **100** has a total weight of approximately 2.4 grams. Alternatively, the container **100** has a total weight in a range of 7.0 grams to 9.0 grams.

FIGS. 5-7 illustrate a second embodiment of the invention. FIG. 5 illustrates a container **200** with an insulating foam support layer **110**, an inner sleeve **120**, and an outer sleeve **230**. As shown in FIG. 5, the container **200** includes a sidewall **202** extending from a bottom wall **204** and a lip **206**. The support layer **110** and inner sleeve **120** are similar to that described above. It will be recognized that the insulating foam support layer **110** and inner sleeve **120** may be switched such that the foam support layer **110** is inside of the polystyrene sleeve **120**.

The outer sleeve **230** is bonded to an outer surface of the foam support layer **110** and is preferably the outermost layer of the container **200**. The outer sleeve **230** allows for a user to print a label or other matter and attach the label to the container **200**. The outer sleeve **230** is made of a material, such as paper, that receives and retains printed media better than foam. The outer sleeve **230** may comprise paper, aluminum, plastic, plastic film, metallic laminations, polypropylene, polyethylene films and/or mixtures thereof. It will be recognized that any other suitable type of material may be used for the outer sleeve **230**. Preferably, the outer sleeve **230** has good printing characteristics to provide improved aesthetic appearance.

The outer sleeve **230** may be bonded to the outer surface of the support layer **110** by glue, a thermal agent, a hot melt and/or a plastic coating. The plastic coating may comprise one or more of polyethylene, polypropylene, or any other suitable polymer or co-polymer or mixtures thereof. The outer sleeve **230**, when bonded, may cover the entire sidewall **112**, flange **116** and bottom wall **114** of the support layer **110**, or just portions of the outer surfaces of the support layer **110**. For example, FIG. 5 illustrates an outer sleeve **230** that covers

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a majority of the sidewall **112** of the support layer **110**. It will be recognized that the outer sleeve **230** may have any suitable shape, size and configuration.

The outer sleeve **230** may have a suitable small thickness **t230** (shown in FIG. 6) such that the thickness **t200** of the container **200** is sufficiently reduced compared to a conventional container **50**. For example, the thickness **t230** of the outer sleeve **230** along a sidewall portion of the support layer **110** is in the range of about 0.06 mm to 0.90 mm. More specifically, the thickness **t230** is in a range of about 0.068 mm to 0.90 mm. The container **200** may have a thickness **t200** in the range of about 2.0 mm to 2.6 mm. More specifically, the thickness **t200** of the container **200** is in a range of about 2.22 mm to 2.564 mm.

According to an embodiment, the outer sleeve **230** has a weight in a range of about 2.3 grams to 3.0 grams. In an embodiment, the total weight of the container **200** is about 9.0 grams to 12.5 grams. More specifically, the total weight of container **200** is about 9.3 grams to 12.3 grams.

It will be recognized that the thicknesses described above are exemplary, and exemplary only. The flange, bottom wall, and sidewall may have varying thicknesses depending upon the overall size of the container **100**, **200**, and/or the thermoforming process.

According to embodiments and features of the invention, embodiments of the invention may be used to form a two or three layer plastic cup with excellent barrier properties, reduced wall thickness, reduced materials costs and excellent aesthetic appearance, while maintaining acceptable rigidity and other characteristics.

It is an object of the invention to provide reduce the costs associated with the materials of a container. It is an other object of the invention to provide a container with good barrier properties such that no substance will leak out of the container. It is another object of the invention to reduce the wall thickness of the container.

Given the disclosure of the present invention, one versed in the art would appreciate that there may be other embodiments and modifications within the scope and spirit of the invention. Accordingly, all modifications attainable by one versed in the art from the present disclosure within the scope and spirit of the present invention are to be included as further embodiments of the present invention. The scope of the present invention is to be defined as set forth in the following claims.

What is claimed is:

1. A method of forming a container comprising:

providing a molded one-piece, insulating, beaded foam support layer including a bottom wall and an upwards extending circumferential sidewall, such that the support layer is seamless, the foam support layer having an inner surface;

thermoforming an unfoamed plastic sleeve including a bottom wall and an upwards extending circumferential sidewall, such that the unfoamed plastic sleeve is seamless, the unfoamed plastic sleeve having an outer surface;

positioning the unfoamed plastic sleeve inside the foam support layer;

bonding the outer surface of the unfoamed plastic sleeve to the inner surface of the foam support layer using a heated mandrel; and

bonding an outer paper sleeve to an outer surface of the foam support layer.

2. The method according to claim 1, wherein the unfoamed plastic sleeve and the foam support layer comprise the same plastic material.

3. The method according to claim 2, wherein the same plastic material is polystyrene.

4. The method according to claim 1, wherein the plastic sleeve is formed such that the thickness of the sidewall is in a range of about 0.101 to 0.127.

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5. The method according to claim 1, wherein the foam support layer is formed such that the circumferential sidewall has a thickness in a range of about 2.17 mm to 2.4 mm.

6. The method according to claim 1, wherein the outer paper sleeve is formed to have a thickness in a range of about 0.068 mm to 0.90 mm.

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7. The method according to claim 1, wherein the container is formed to have a total weight in a range of about 9.0 grams to 12.5 grams.

8. The method according to claim 1, wherein the container is formed to have a total weight in a range of 9.3 to 12.2 grams.

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9. The method according to claim 1, wherein the container is formed with only three layers, which comprise the thermoformed plastic sleeve, the molded foam support layer, and the paper sleeve.

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